

Patent Claims

1. A method of producing hollow bodies (H) of plastic by stretch-blow molding heated parison (V), where the parisons are inspected and defective parisons are sorted out, characterized in that the parisons (V) are inspected before being heated and at least some of the defective parisons (V) are heated and are sorted out only after being heated.

2. The method according to Claim 1, characterized in that the defective parisons (V) which can be heated with no problem are sorted out only after being heated and the defective parisons (V) which pose problems in heating can be sorted out even before being heated.

3. The method according to Claim 2, characterized in that the defective parisons (V) having a slightly oval mouth are sorted out after being heated and the defective parisons (V) with a markedly oval or constricted mouth are separated out before being heated.

4. The method according to Claim 2 or 3, characterized in that the acceptable parisons (V) which are adjacent to a gap created by sorting out a defective parison (V) before being heated are sorted out after being heated.

5. A device for producing hollow bodies (H) from plastic by stretch-blow molding heated parisons (V), comprising a heating station (2), a downstream blow molding station (1) and an upstream inspection station (3), characterized in that a sorting station (4) which is controllable by the inspection station (3) is situated between the heating station (2) and the blow molding station (1) for sorting out defective parisons (V).

6. The device according to Claim 5, characterized in that an additional sorting station (5) which is also controllable by the inspection station (3) is situated between the inspection station (3) and the heating station (2) for sorting out defective parisons (V).

7. The device according to Claim 6, characterized in that the inspection station (3) has an analyzer device (3) which differentiates between defective parisons (V) having a defect-free or only slightly oval mouth on the one hand and defective parisons (V') having a markedly oval or constricted mouth on the other hand and which causes the latter to be sorted out before the heating station (2) while they are in the additional sorting station.

8. The device according to one of Claims 5 through 7, characterized in that the inspection station (3) is situated at an intake star wheel (7) which is upstream from the heating station (2) and the sorting station (4) is situated at a transfer star wheel (8) which is located between the heating station (2) and the blow molding station (1).

9. The device according to Claim 8, characterized in that the additional sorting station (5) is located at the intake star wheel (7).